

Work Order ID 81487-

81487

March-14-12 4:21:38 PM

Page 1

Item ID: D3637-041

Revision ID:

Item Name: Bracket Assembly

Start Date: 14/03/2012 Start Qty: 16.00

Required Date: 23/03/2012 Req'd Qty: 16.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: *see*

Date: *11/03/12* Tooling:

Run Start *NR1*

QC:

Date: *11/03/12* SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 Dwg Rev: *B* Prog Rev: *B* 2-
Deburr if necessary

B12-3-10

(Signature)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SA 12/3/20

SP2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Split

Ship Today

Work Order ID 81487-2

81487

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Item ID: D3637-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket Assembly

Stop *NS2*

Start Date: 14/03/2012 Start Qty: ~~16.00~~ 8

16

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

130

Brake NC

NC BRAKE

Memo

0.00

0.00

Brake NC

Form as per Dwg D3637

12/02/09

2.2

140

140

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

1- drill holes as per dwg using DT89792-C Sink as per Dwg D3637 3-
Install Nut plate as per Dwg D3637

GP 12/04/09 (8)

150

150

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/2/09/09

78

Quality Control

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Item ID: D3637-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket Assembly

Stop ***NS2***

Start Date: 14/03/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: **245A**

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/4/12

80

MLJ 12/04/04

R12-044

Picklist Print

March-14-12 4:21:41 PM

Page 1

Work Order ID: 81487

81487

Parent Item: D3637-041

D3637-041

Parent Item Name: Bracket Assembly

Start Date: 14/03/2012

Required Date: 23/03/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 Rivet		Purchased	No			100	Each	5,075.000	2	32		12/04/04	

MS20426AD3-3

Rivet

Location

Loc Qty

Loc Code

ST316

5075

119109

1640

121011

3000

19099

435

M304S14GA

Purchased

No

140

sf

102.6000

0.09

1.515789

M304S14GA

304SS sheet .080

Location

Loc Qty

Loc Code

MAT020

102.6

117933

6.6

119276

96

MS21059L4

Purchased

No

140

Each

47.0000

1

16

MS21059L4

Nutplate

Location

Loc Qty

Loc Code

ST301

22

117887

3

119623

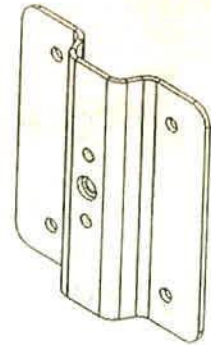
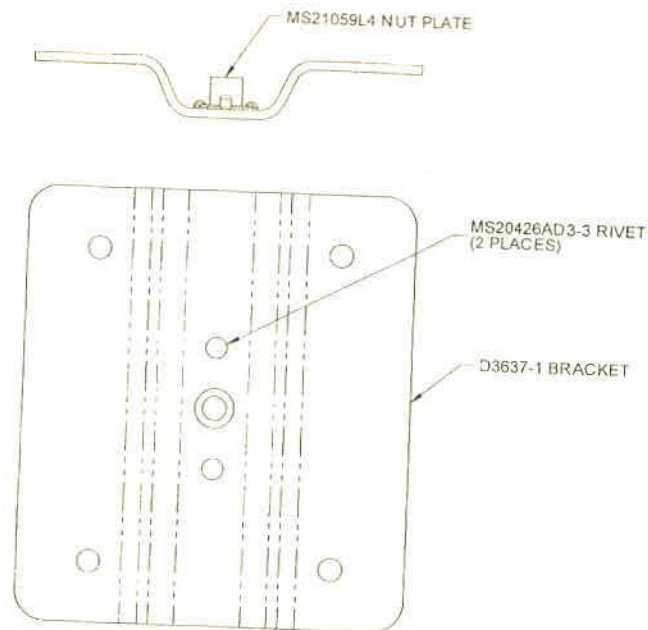
19

ST302

25

120930

25



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. E1483 4105

12/03/14

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637-1, 1 IS WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE, REPLACES G10608, G10602 & G10609	LE	07.07.27
REV	DESCRIPTION	BY	DATE
DESIGN	JS		
DRAWN	JS		
CHECKED	JS		
MFG APPR.	JS		
APPROVED	JS		
DE APPR.	JS		
DATE	07.12.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3637** REV. B
TITLE **BRACKET** SCALE 1:1
SHEET 1 OF 3

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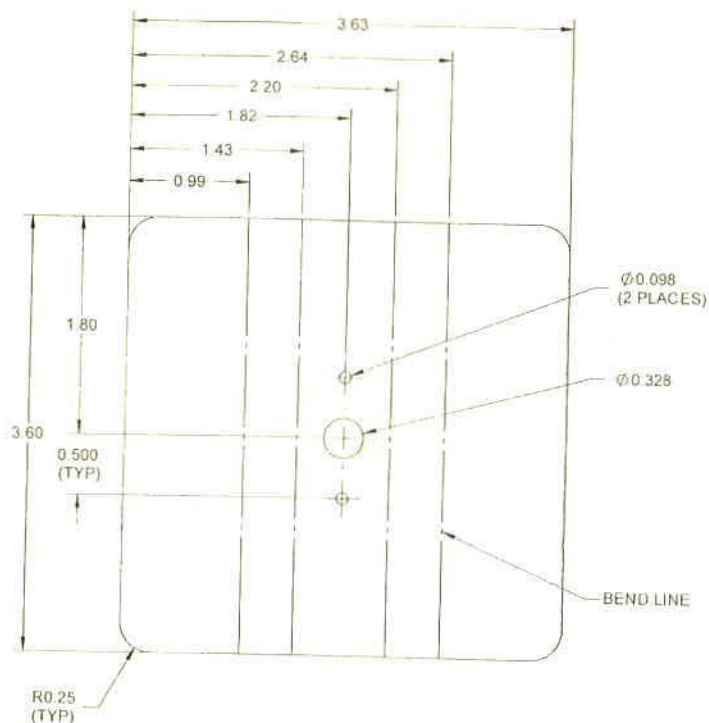
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

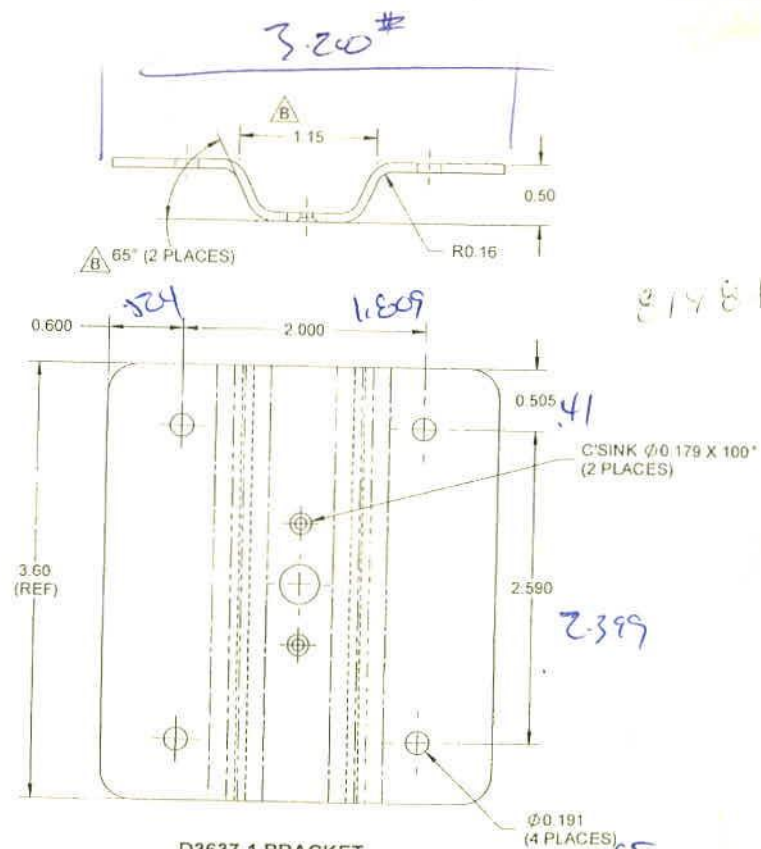
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



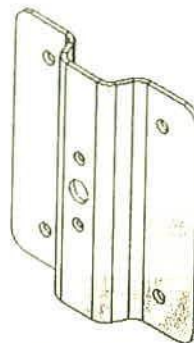
D3637-1F FLAT PATTERN



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)

D3637-1 NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs



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DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AL	DRAWING NO.	REV. B
MFG APPR	GP	D3637	SHEET 2 OF 3
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DE APPR	MT	BRACKET	1:1
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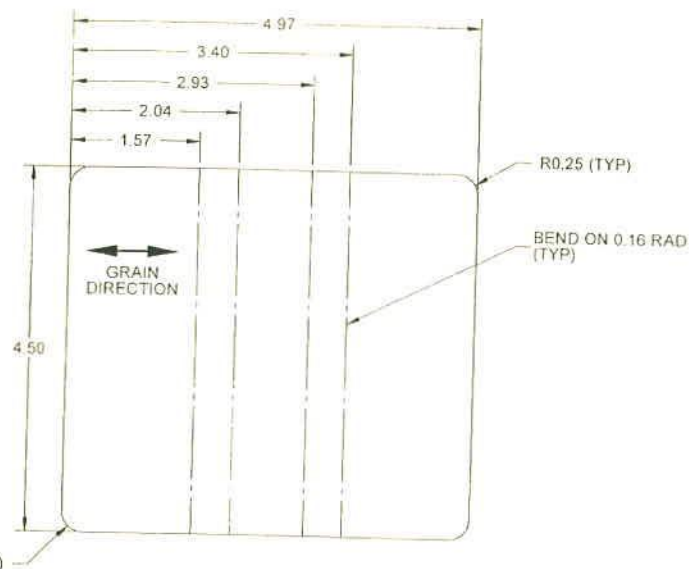
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

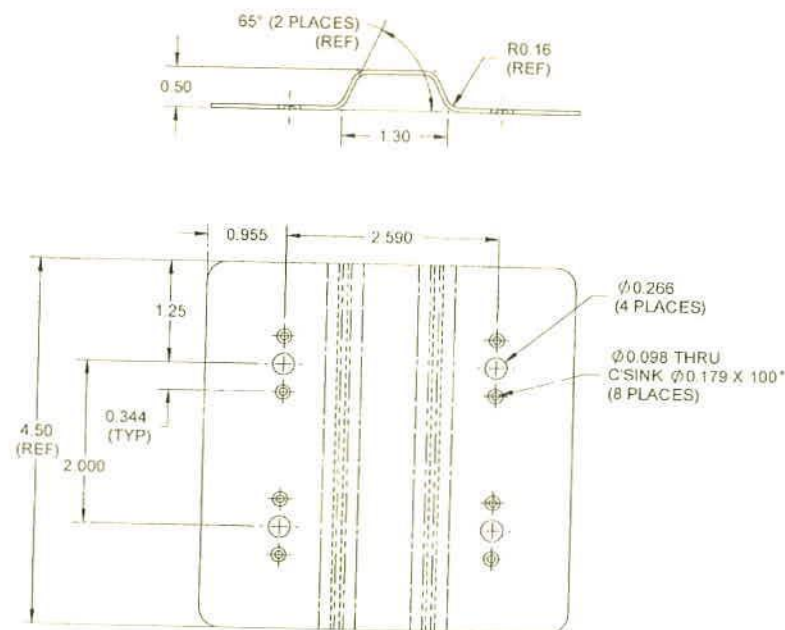
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



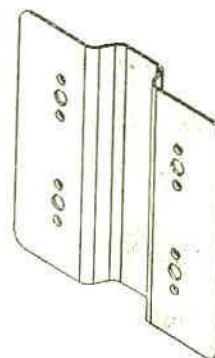
D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**

D3637-3 NOTES

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs.



DESIGN	TS	DART AEROSPACE LTD	
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CHECKED	Ref	DRAWING NO	REV B
MFG APPR	CO	D3637	SHEET 3 OF 3
APPROVED	MA	TITLE	SCALE
DE APPR	MA	BRACKET	2:3
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries